

Date: 4 Monday, 2/4/2008 11:22:57 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAM LOCK SHAFT
Job Number : 37150	
Estimate Number : 10476	
P.O. Number :	Part Number : D33933
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35809	Material :
Written By : <u>08 02 04</u>	Due Date : 2/18/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 02 04</u>	
Comment : EsT A 05.02.18 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0375	303 Round Bar 0.375"
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Comment: Qty.: 0.1225 f(s)/Unit Total : 2.4507 f(s)

Material: AISI 303 SS Rod Ø0.375

(M303R0.375)

Batch: M100817

(20)

H.A 08/02/07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA509 and Dwg D3393

Machine D3393-3 as per Folio FA509 and Dwg D3393

Identify as D3393-3

Deburr

(20)

H.A 08/02/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(20)

H.A 08/02/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA509 and Dwg D3393

(20)

H.A 08/02/07

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(20)

H.A 08/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:57 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAM LOCK SHAFT

Job Number: 37150

Part Number: D33933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08-02-08

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/22/07

AS 08/02/11

(20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST90

AS 08/02/11

(20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08 02 13

20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-02-14 (20)

W

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

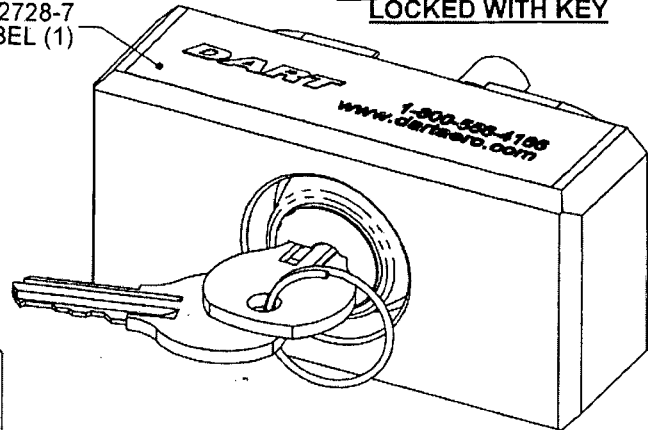
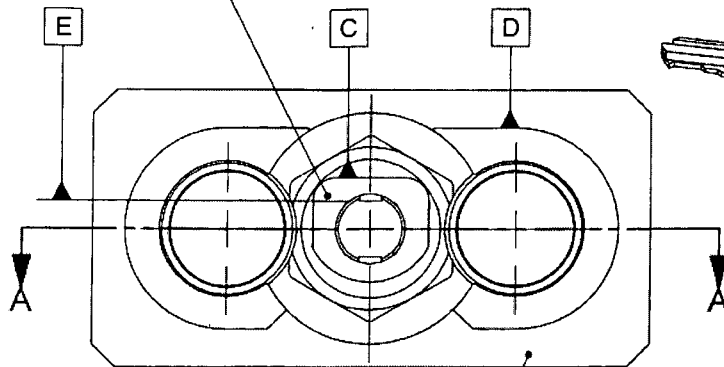


**DART**

DESIGN 43	DRAWN BY 43	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED [Signature]	DRAWING NO. <b>D3393</b>	REV. A SHEET 1 OF 3
DATE <b>05.02.08</b>		TITLE <b>BATTERY LOCK</b>	SCALE 1:1
A	05.02.08	NEW ISSUE	

**RELEASED**  
[Signature]

05/03/09

D2728-7  
LABEL (1)**BATTERY LOCK SHOWN  
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5  
PARALLEL TO FACES **D** AND **E**  
AS SHOWND3373-1  
CAM LOCK  
ASSEMBLY (1)D3393-1  
CASING (1)Ø5/16" WC S/S  
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2)   
AND APPLY KRAZY GLUE0.09<sup>+0.03</sup>  
-0.01 (2 PLACES)D3393-3 CAM  
LOCK SHAFT (1)TACK WELD  
D3393-3 TO D3369-5**SECTION A-A**SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **37150****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

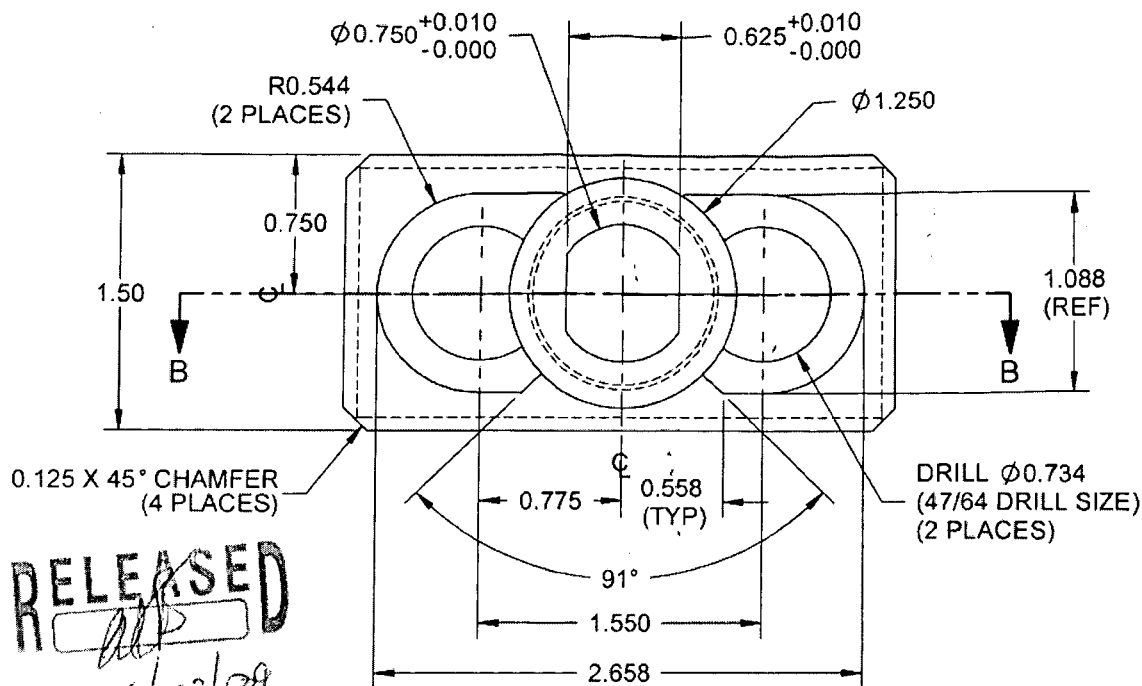
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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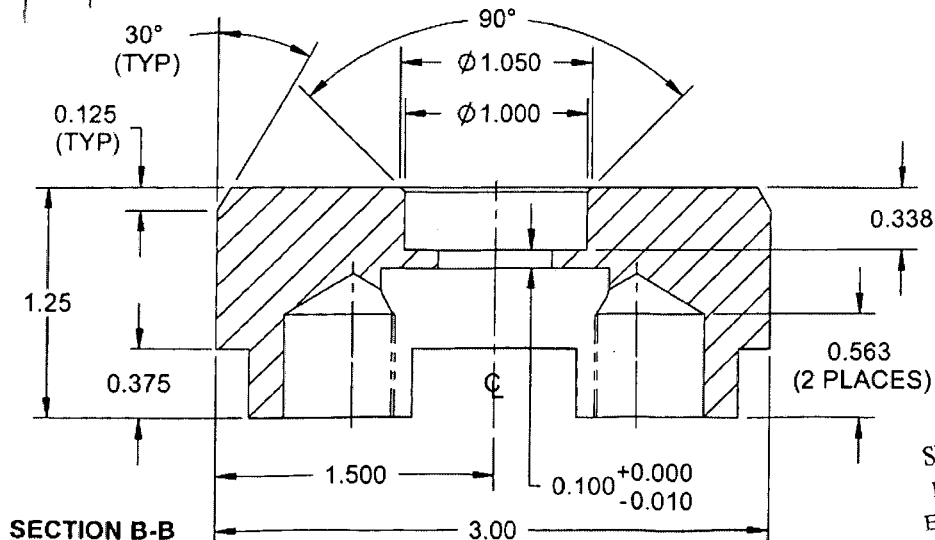
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A SHEET 2 OF 3
DATE <b>05.02.09</b>	TITLE <b>BATTERY LOCK</b>		SCALE 1:1



RELEASED  
*[Signature]*  
05/03/09

**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

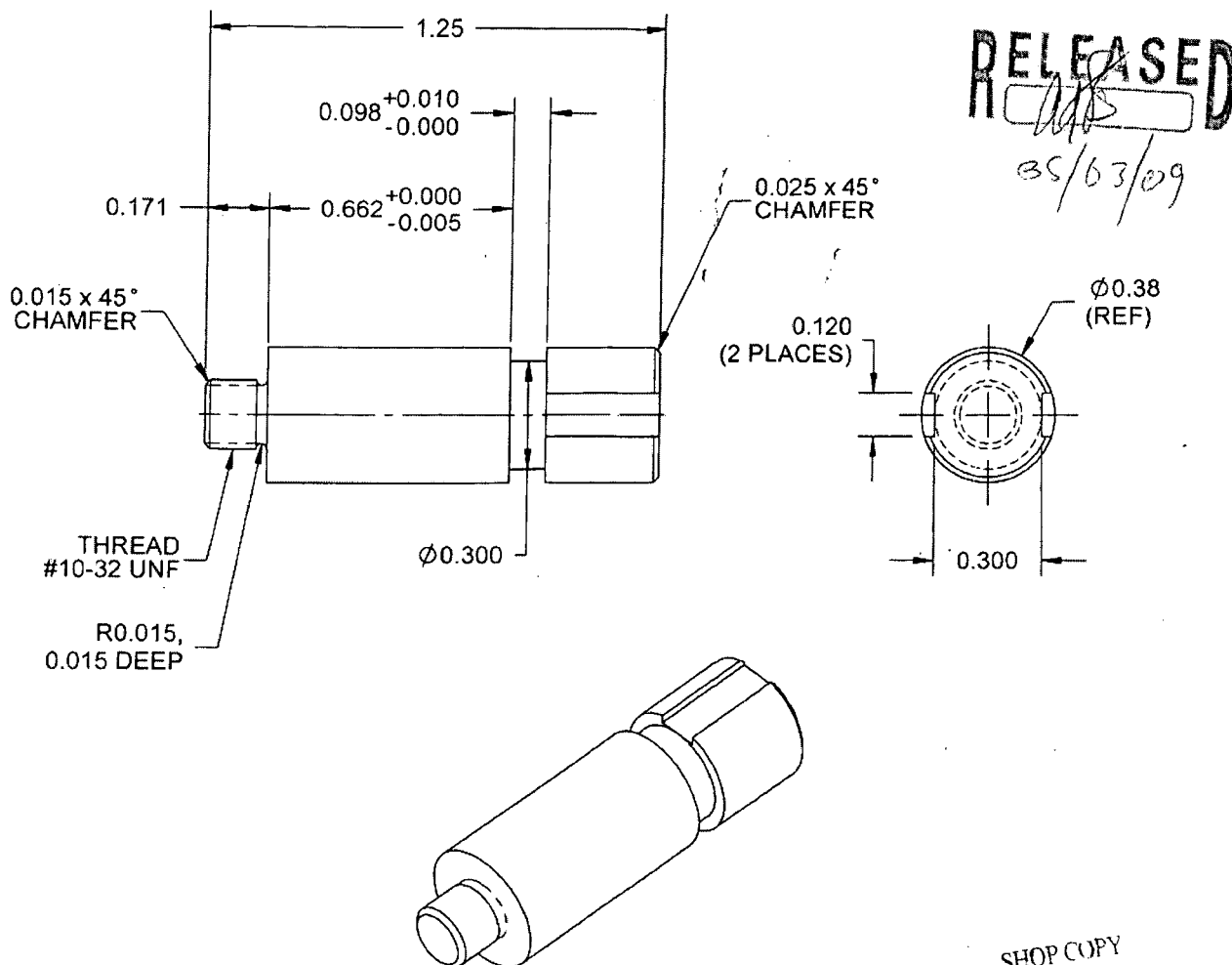
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DATE <b>05.02.09</b>		TITLE <b>BATTERY LOCK</b>	SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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